

Date: Monday, 22/09/2008 3:37:59 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PANEL-350 AFT CANOPY
Job Number :	42208	Part Number :	D36561
Estimate Number :	13098	Drawing Number :	D3656 REV. A
P.O. Number :		Project Number :	00204
This Issue :	22/09/2008	Drawing Revision :	A
Prsht Rev. :	NC	Material :	
First Issue :	//	Due Date :	26/09/2008
Previous Run :	39710	Qty:	3 Um: Each
Written By :			
Checked & Approved By :			
Comment :	Est. Rev. A 07/12/13 DL verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 32.0000 sf(s)/Unit Total : 96.0000 sf(s)

GE PLASTICS LEXAN SHEET

batch: M 105494

Wh 08-09-23

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

Wh 08-09-23

3.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-1 and Folio FTA 015 using tool DT 8986

K4.

Dwg. Rev. B

Folio Rev. A

Wh 08-09-23

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

Wh 08-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3656-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 42208		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/24	4.	SHEET TOO HOT. WEBBING IN PART.	WAB 08/09/25	Scrap & Replace. B# 105494 QTY @	08/09/24 W.H.	S 08/09/25	WAB 08/09/25	S 08/09/25

NOTE: Date & initial all entries

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 AFT CANOPY

Job Number: 42208

Part Number: D36561

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8080925

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

(3)

1) Trim to Finished Dimensions as per dwg D3656

DL 08.09.24 PTO

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(3)

Check dimensions to ensure conformity to drawing tolerances.

DL 08.09.24

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8080925

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPD 42207

8/9/25

SV

(3x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



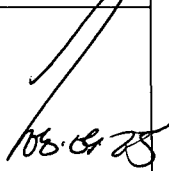
Comment: FINAL INSPECTION/W/O RELEASE

0809/25

Job Completion



MF 08-09-25

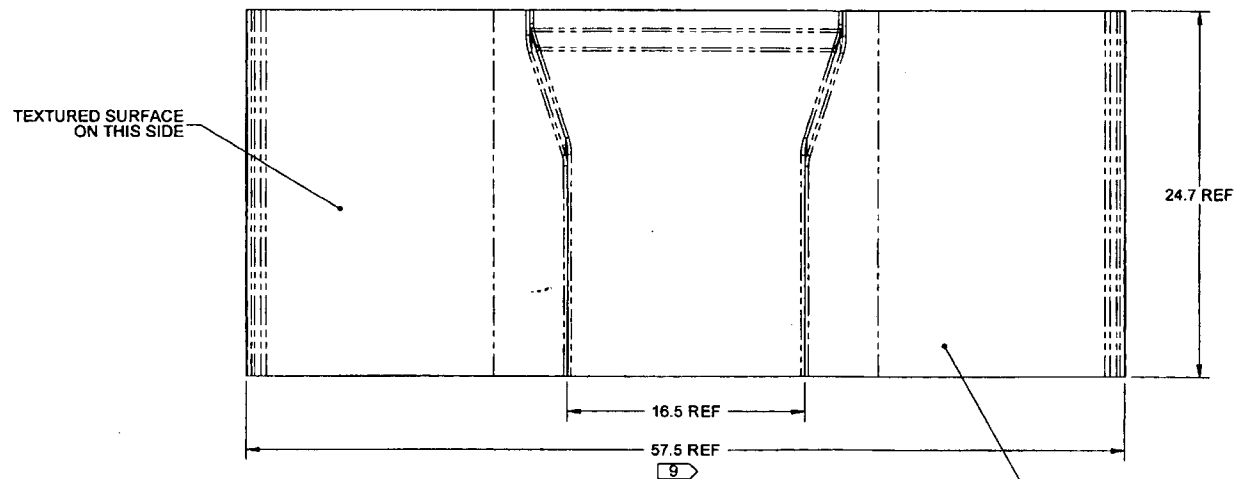
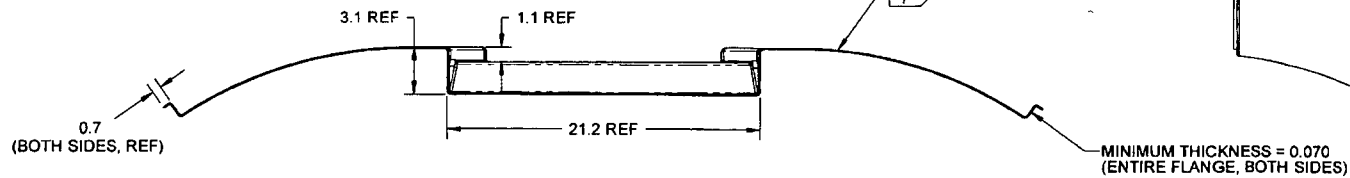
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.09.25	6	THE SKYLIGHTS DOES NOT NEED TO BE TRIMMED (ZN C2-2) PERMANENT CHANGE. DWG TO BE UPDATED	PH	08.09.25	ALL	PH 08.09.25	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3656-1 PANEL

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022 TRIM PER MOLD DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE		
DRAWN	LE		
CHECKED	LE		
MFG. APPR.	MP		
APPROVED	MP		
DE APPR.	MP		
DATE	08.03.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3656	REV. A
TITLE PANEL	SCALE NTS

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	42208
Description: Panel		Part Number:	D3656-1
Inspection Dwg: D3656	Rev: AB Dh A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

Measured by: Dh

Date: 08.09.24

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.7	+/-0.030	0.714	✓		Visual	Visual
0.070	Min	0.101	✓		Visual	Visual
0.050	Min	0.054	✓		Visual	Visual

Measured by: Dh

Date: 08.09.24

Audited by: S

Date: 08/09/24

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL	Dh